

SPLIT

Date: Monday, 1/8/2007 10:42:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30137 - 1
 Estimate Number : 11483
 P.O. Number : N/A
 This Issue : 1/8/2007 S.O. No. : N/A
 Prsh Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 28120
 Written By :
 Checked & Approved By :
 Comment : Est: C 99.01.18 Re-format DM

Drawing Name : ASPIRATOR
 Part Number : D2091
 Drawing Number : D2091REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 1/30/2007 Qty: 19 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2000043	Jet
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s) Jet Pick: Qty Part Number Description Batch 1 D2000-043 Jet B28128 (19) <i>Mo 1/3/07</i> (19)
2.0	D2094	Aspirators
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s) Aspirator Pick: Qty Part Number Description Batch 1 D2094 Aspirator Body B30153 <i>SP 07/02/05</i> (19) <i>Mo 1/3/07</i>
3.0	D2095	Aspirator
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s) Aspirator Pick: Qty Part Number Description Batch 1 D2095 Aspirator Core B30154 <i>SP 07/02/05</i> (19) <i>Mo 1/3/07</i>
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		Comment: LARGE FAB RESOURCE 1 Weld D2000-043 Jet to D2094 Aspirator Body as per Dwg D2091 using Jig DT8294 <i>Mo 1/3/07 (19)</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:42:13 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 30137

Part Number: D2091

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-03-06 (19)

6.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING

Issue P/O: 3262

Black Anodize weldment from step 3 and Dwg D2095

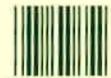
7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ANODIZE

J0703-16 (19)

8.0 A1449 Grommet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 200.0000 Each(s)

Grommet

76

Pick:

Qty	Part Number	Description	Batch
4	A1449	Grommet	M1487

FF 07-03-20

19

9.0 A1622 Grommet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 200.0000 Each(s)

Grommet

76

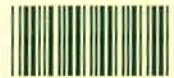
Pick:

Qty	Part Number	Description	Batch
4	A1622	Grommet	M1487

FF 07-03-20

19

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install grommets as per Dwg D2091

FF 07-03-20

19

11.0 QC5 INSPECT WORK TO CURRENT STEP



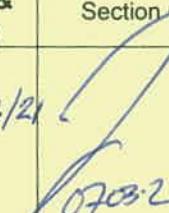
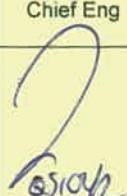
Comment: INSPECT WORK TO CURRENT STEP

J0703-21

(P10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/21	10.0	7 parts need 1 grommet piece changed. 5xel installation due to flange being in the hole.	 QS10U12	Re-work 7 parts.	FF 07/03/21	 07/03/21	 QS10H	 07/03/21

NOTE: Date & initial all entries

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Drawing Name: ASPIRATOR

Job Number: 30137

Part Number: D2091

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pc 1/3/21 (19)

13.0 QC21

FINAL INSPECTION/W/O RELEASE



(19)

Comment: FINAL INSPECTION/W/O RELEASE

Q 07/03/22

Job Completion



u 07.03.22

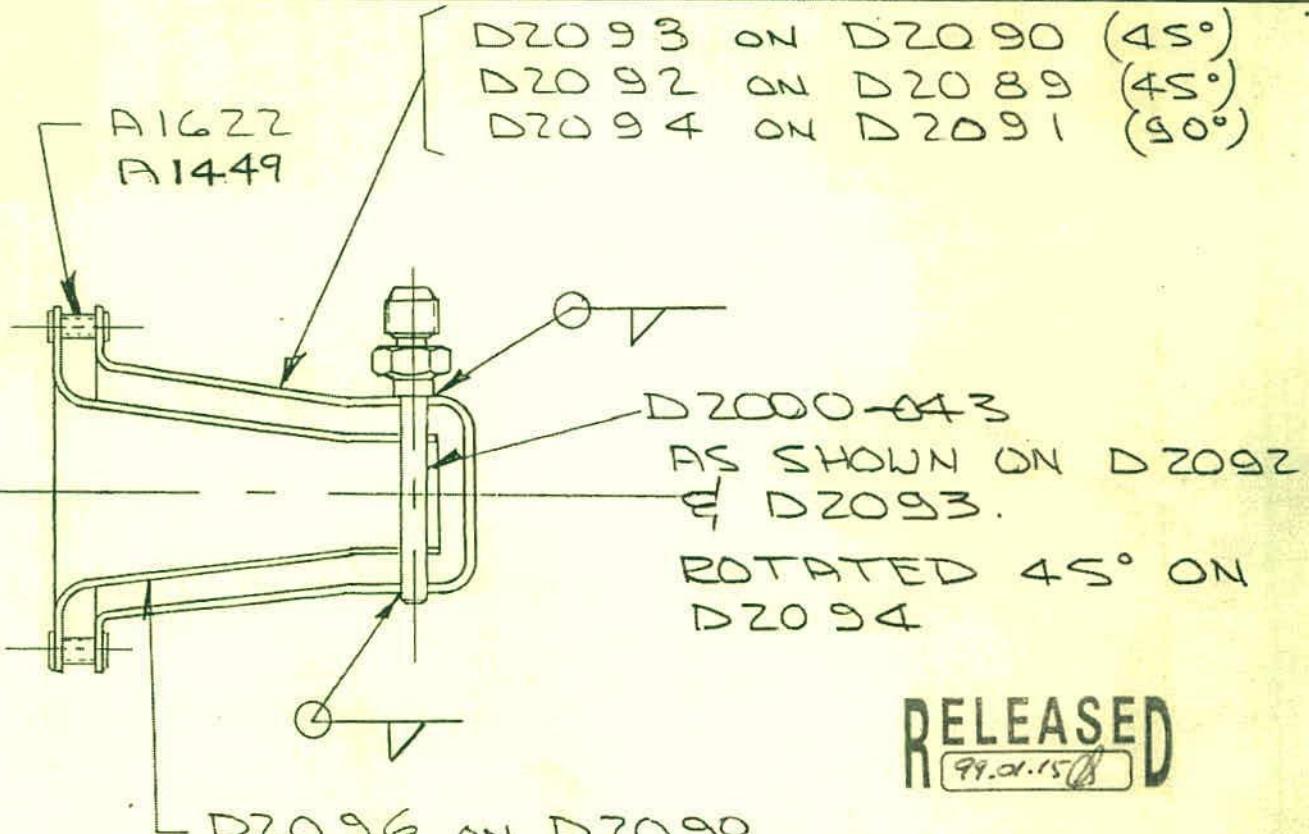
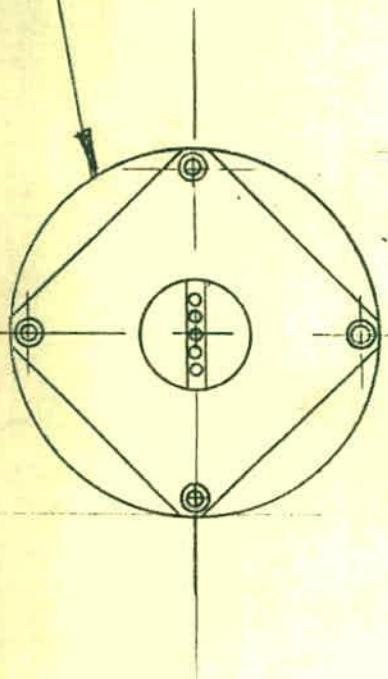
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2092 SHOWN



RELEASED
99.01.15

FINISH:

BLACK ANODIZE AFTER WELDING &
PRIOR TO RIVETING.

NO. 3015
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOT COPY

THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.

REQUIREMENTS - UNLESS OTHERWISE SPECIFIED

GENERAL

LIMITS

1. DIMENSIONS ARE IN INCHES
2. SURFACE ROUGHNESS $\frac{1}{16}$ " MAX
3. REMOVE SHARP EDGES .015 MAX
4. THREADS PER INCH - S - 2742
5. HOLES PER INCH 10247

1. TOLERANCES - JXX ± .030
2. ANGLES ± $\frac{1}{16}$ "
3. PARALLELISM .0025
4. ECCENTRICITY .005 MAX
5. STRAIGHTNESS ABOUT ALL MTC CENTRE LINES .005

REPORT ALL DISCREPANCIES - DO NOT SCALE

RIVET CODE SHALL BE PER NAS 523

BASIC CODE

Q= DASH NO.
M= HEAD HEAR SIDE
F= HEAD FAR SIDE

BASIC CODES

8J=M520470AD

8B=M520426AD

PART NO.

CONTRACT NO.

DRAWN

DESIGN

DATE

1992

ITEM

DESCRIPTION

MADE BY

DART

VANCOUVER

CANADA

DART AERO ACCESSORIES INC.

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C

ASPIRATORS

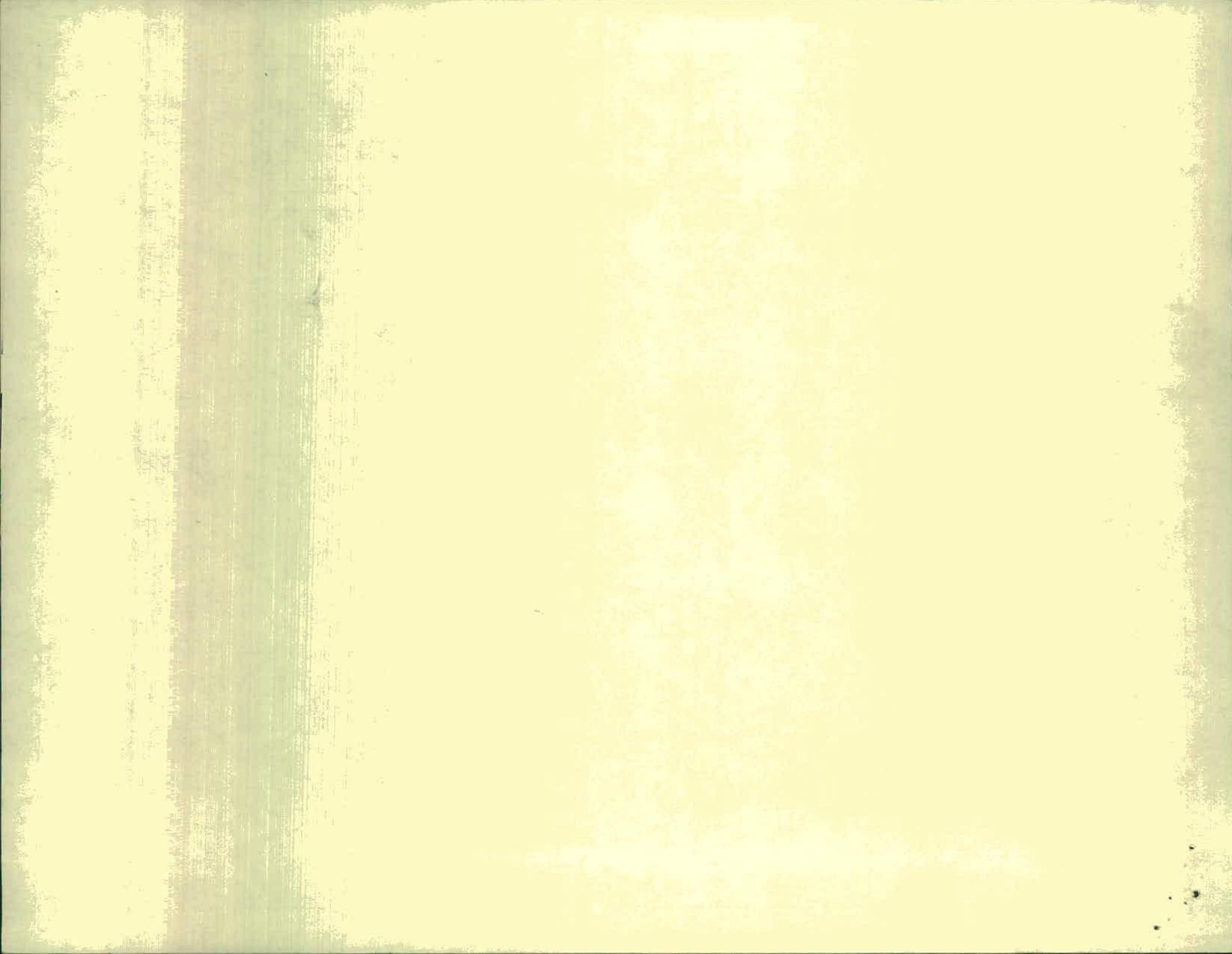
D2089/90/91

REV A

SCALE 1:2 SHT 1 OF 1

D2089/90/91

A



TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

PACKING
SLIP

53589

14-Mar-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY ONTARIO

K6A 1K7

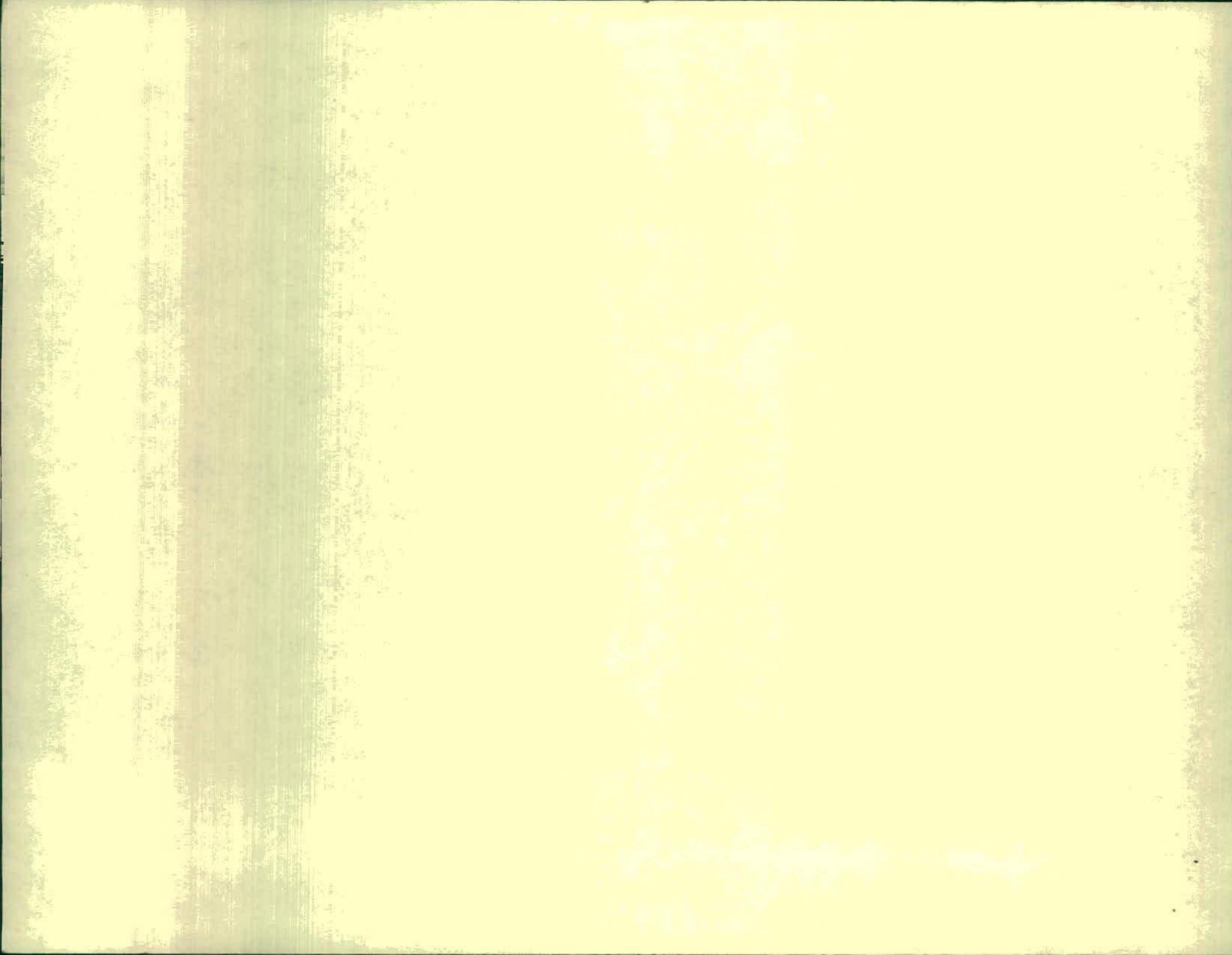
**PURCHASE ORDER/
NO. DE COMMANDE:** 00003262

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	
1	19	19	D2094	B30137
2	19	19	D2095	B30137

PICKED UP BY / REÇU: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.





21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
 Telephone: (514) 429-7777 Fax: (514) 429-5108
 Certifié ISO 9001-2000 / AS9100 certified
 approuvé NADCAP approved

53589

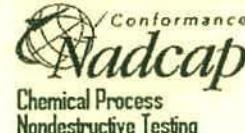
14-Mar-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
 1270 ABERDEEN STREET
 HAWKESBURY , ONTARIO
 K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/
NO. DE COMMANDE: 00003262



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	19	19	D2094 B30137	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2
2	19	19	D2095 B30137	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
 Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
 Travel cards have been filed and are available for viewing upon request.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager



TNM

ANODISATION et PEINTURE TNM INC.



21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

FACTURE
INVOICE

53589

14-Mar-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY ONTARIO

K6A 1K7

PURCHASE ORDER/
NO. DE COMMANDE: 00003262

CONDITIONS / TERMS:

NET 30 JOURS / NET 30 DAYS

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIBTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	19	19	D2094 B30137	\$0.00	\$0.00
2	19	19	D2095 B30137	\$0.00	\$0.00
<i>RC 7/3/05</i>					MINIMUM CHARGE
					\$180.00
					SUB TOTAL: \$180.00
					TPS/GST: \$10.80
					TVQ/PST: \$0.00
					TOTAL AMOUNT DUE: \$190.80

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE

CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

